

Date: Friday, 01/08/2008 3:32:27 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FRONT OUTBOARD LEG (LH)		
Job Number :	40973				
Estimate Number :	13376				
P.O. Number :		Part Number :	D37683		
This Issue :	01/08/2008	S.O. No. :		Drawing Number :	D3768 REVA
Prsht Rev. :	NC	Project Number :	N/A		
First Issue :	1/1	Type :	MACHINED PARTS		
Previous Run :	40313	Drawing Revision :	A		
		Material :			
Written By :		Due Date :	21/08/2008	Qty:	10 Um: Each
Checked & Approved By :	<u>JL 08.8.05</u>				
Comment :	Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 0.8969 f(s)/Unit Total: 8.9691 f(s)
 6061T6 TUBE (1.00" x 0.65" wall)
 batch: M 108819

Rq 08/08/06

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA757 Rev: A & Dwg D3768 Rev: A

2-Deburr per dwg D3768

Rq 08/08/06

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Rq 08/08/06

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 08/08/06

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

Rq 08-08-06

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:32:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT OUTBOARD LEG (LH)

Job Number: 40973

Part Number: D37683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 180 52



(10X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

10:30

OVEN TEMPERATURE:

320 °F

FINISH TIME:

11:00

M. 08/08/07

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-07

(X12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 118

8/8/7

50

(10X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/08/08

MF 08-08-08

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

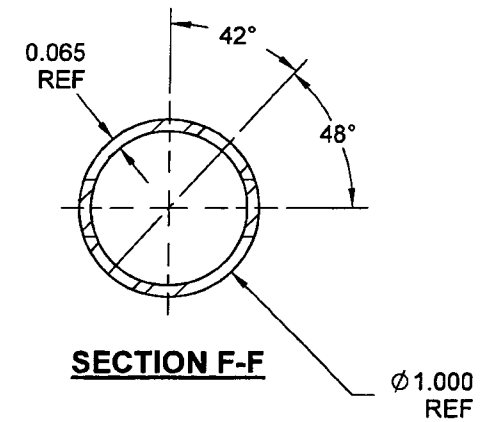
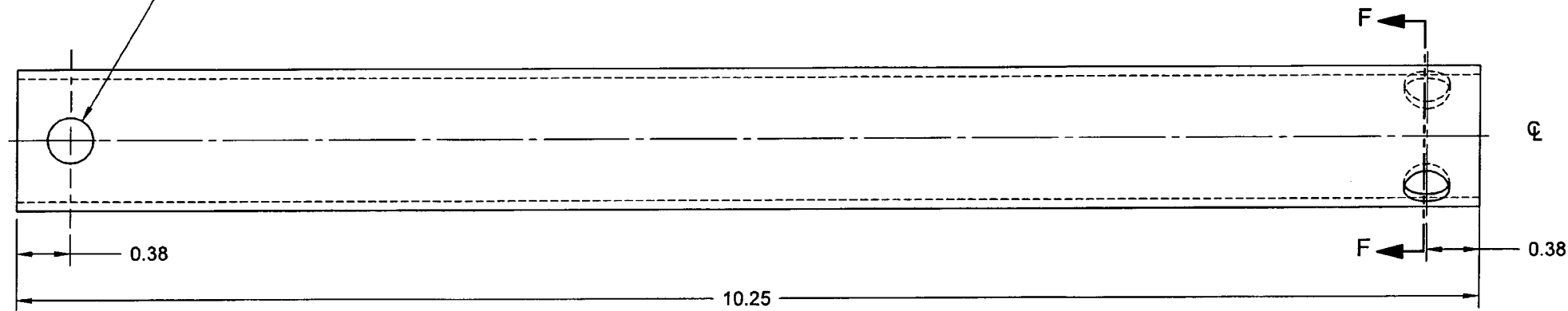
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Ø0.323
THRU
2 PL



D3768-4 FRONT OUTBOARD LEG, RH

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DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	HS	DRAWING NO. D3768	REV. A
MFG. APPR.	HS		SHEET 4 OF 4
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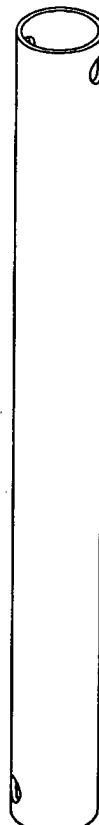
C

B

A



D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH



D3768-4 FRONT OUTBOARD LEG, RH

NOTES:

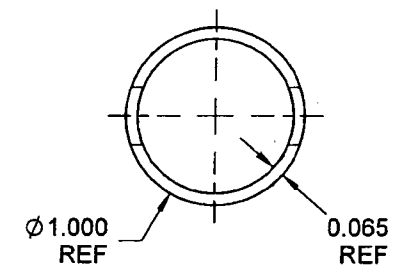
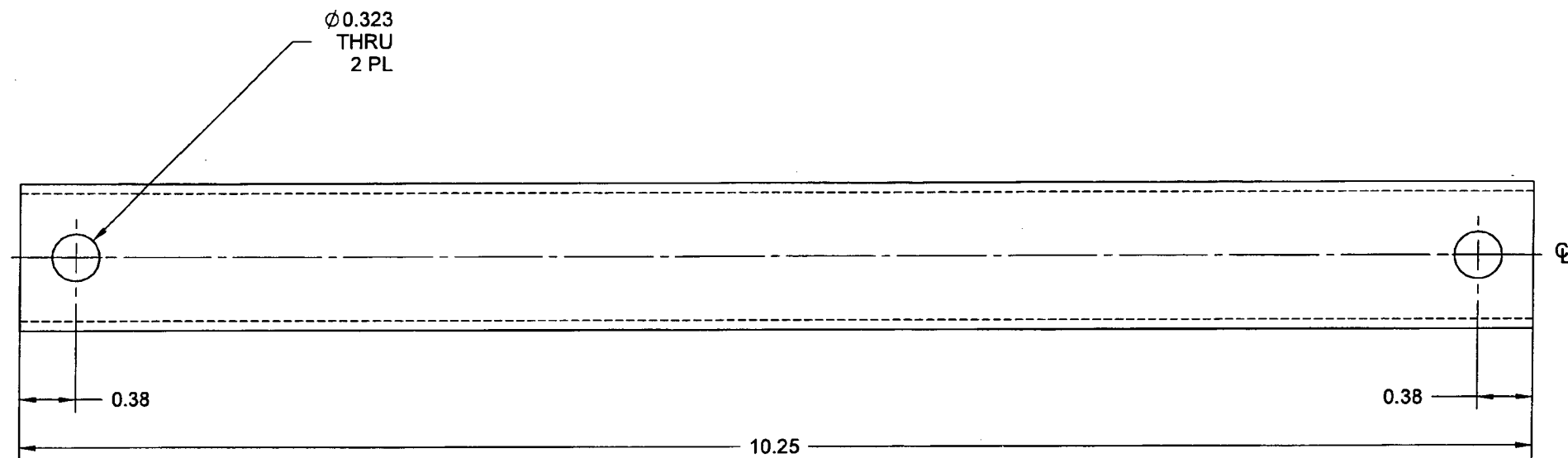
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER VW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A	NEW ISSUE	HS	08.06.04
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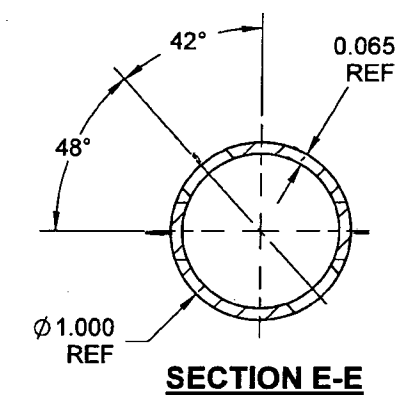
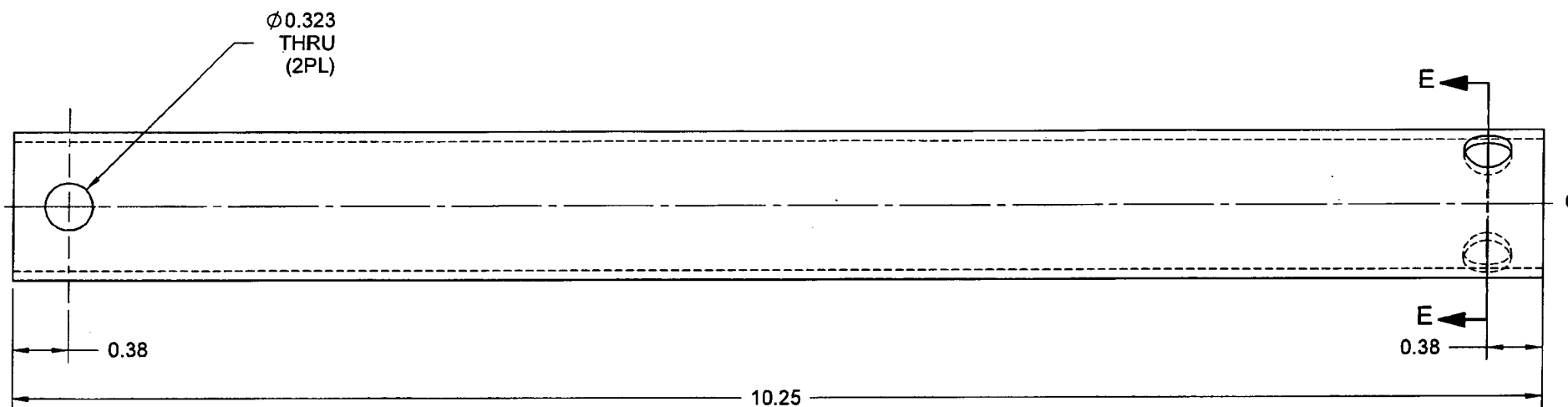


D3768-1 FRONT INBOARD LEG

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D3768-3 FRONT OUTBOARD LEG, LH

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